

Date: Tuesday, 4/25/2006 7:35:12 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 350 SKIDTUBE EXTRUSION (BENT)		
Job Number	: 26787		Part Number	: D26003BENT		
Estimate Number	: 10997		Drawing Number	: D2600 REV D1		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 4/25/2006	S.O. No. : N/A	Drawing Revision	: D1		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 5/5/2006		
Previous Run	: 25384		Qty:	30		
Written By	: <u>Seq</u> (Comment Below)		Um:	Each		
Checked & Approved By	: <u>KJ</u> 06.04.25		Qty:	49		
Comment	: Est. B02/11.28 Reformat KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:								
1.0	D26003120	Extrusion Round 3" 350 								
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)</p> <p>Extrusion Bent</p> <p>Pick:</p> <table border="1"> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> <tr> <td>1</td> <td>D2600-3</td> <td>Extrusion</td> <td><u>B23201</u></td> </tr> </table> <p><i>DP 05-6-31</i></p>			Qty	Part Number	Description	Batch	1	D2600-3	Extrusion	<u>B23201</u>
Qty	Part Number	Description	Batch							
1	D2600-3	Extrusion	<u>B23201</u>							
2.0	BENDING	BENDING MACHINE 								
<p>Comment: BENDING MACHINE</p> <p>Deburr one end of extrusion</p> <p>Drill #30 pilot holes using DT8689</p> <p>Open holes to 5/16" and deburr</p> <p>Bend using CNC bending machine as per program 2750.C and Folio FT003.</p> <p>Use 5/16 locator pin on buggy "A".</p> <p>Check fit to Jig DT8150</p> <p><i>DP 05-6-31</i></p> <p><i>DP 05-6-31</i></p> <p><i>DP 05-6-31</i></p>										
3.0	QC5	INSPECT WORK TO CURRENT STEP 								
<p>Comment: INSPECT WORK TO CURRENT STEP</p> <p>Inspect work to Step 6 Ensure fit to Jig DT8150</p> <p><i>BE 05-6-31</i></p> <p><i>49</i></p>										

4.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #</p> <p>Identify and Stock</p> <p>Location: <u>416</u> <i>DP 05-6-31</i> <i>49</i></p> <p><i>PTO</i></p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2600-3B PAR #: N/A Fault Category: Prod/Landing Gear NCR: Yes No DQA: DK Date: 06/06/01
 QA: N/C Closed: DK Date: 06.06.01

NCR: <u>26787</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>06-05-01</u>	<u>2.</u>	<u>Take over last overload</u>	<u>DK</u> <u>06-05-01</u>	<u>Take over last Scrap & destroy & Replace.</u>	<u>DK</u> <u>06-05-01</u>	<u>BE</u> <u>06-05-01</u>	<u>DK</u> <u>06-05-01</u>	<u>DK</u> <u>06-05-01</u>

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 7:35:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE EXTRUSION (BENT)

Job Number: 26787

Part Number: D26003BENT

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/06/01 *77*

Job Completion



U 060601

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DKY</i>	DRAWN BY <i>DKY</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

A	97.01.21	NEW ISSUE
B	97.09.09	CHANGE MATERIAL SPEC.
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.
D	98.08.20	INCREASE MIN. UTS TO 40 KSI
DI	01.04.17	ADD PART NUMBERS + DIE NUMBERS <i>+ GP</i>

RELEASED
18.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
TO ASTM STANDARD B221 BY AN APPROVED TESTING
FACILITY TO ENSURE THAT THE BATCH MEETS THE
ABOVE MINIMUM MECHANICAL PROPERTIES.

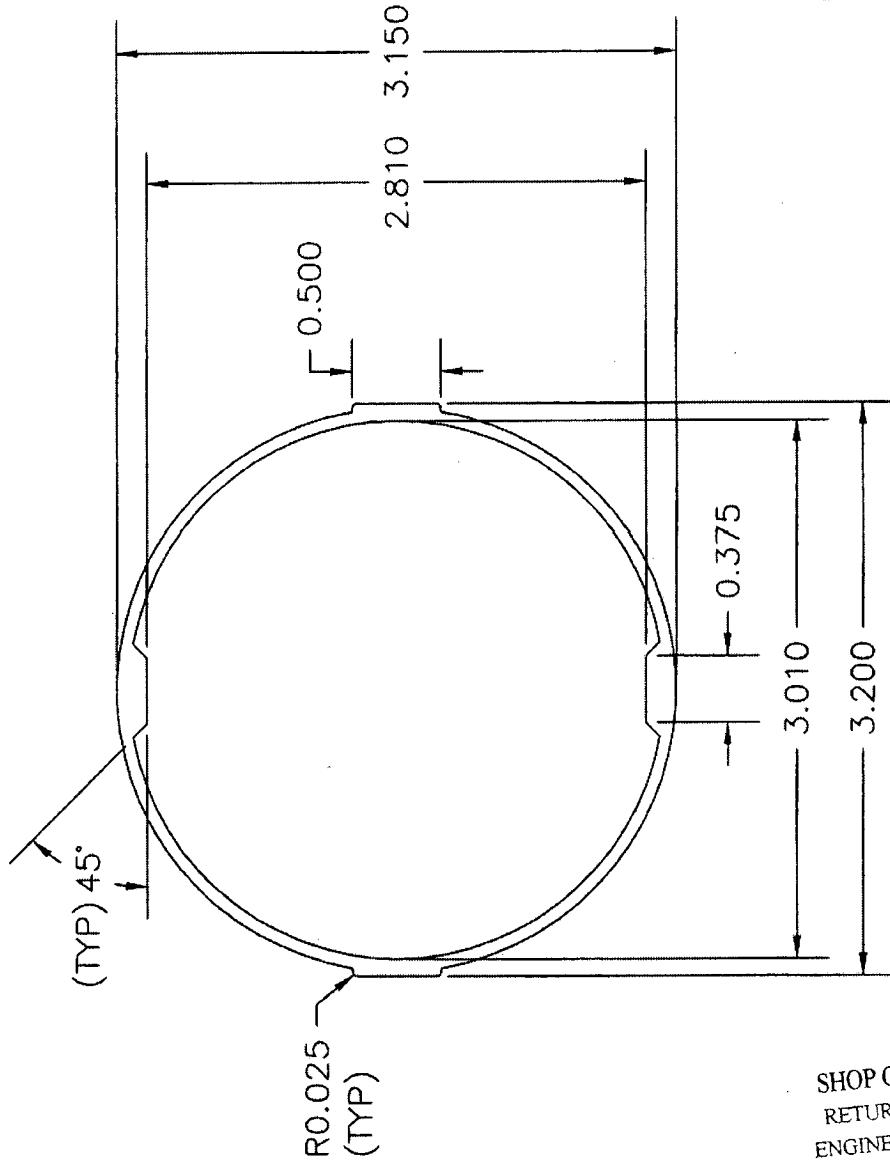
2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

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03/03/98

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D2600-1

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MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)



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DATE	98.08.20	DRAWING NO.
		D2600

TITLE EXTRUSION

SCALE

REV. D

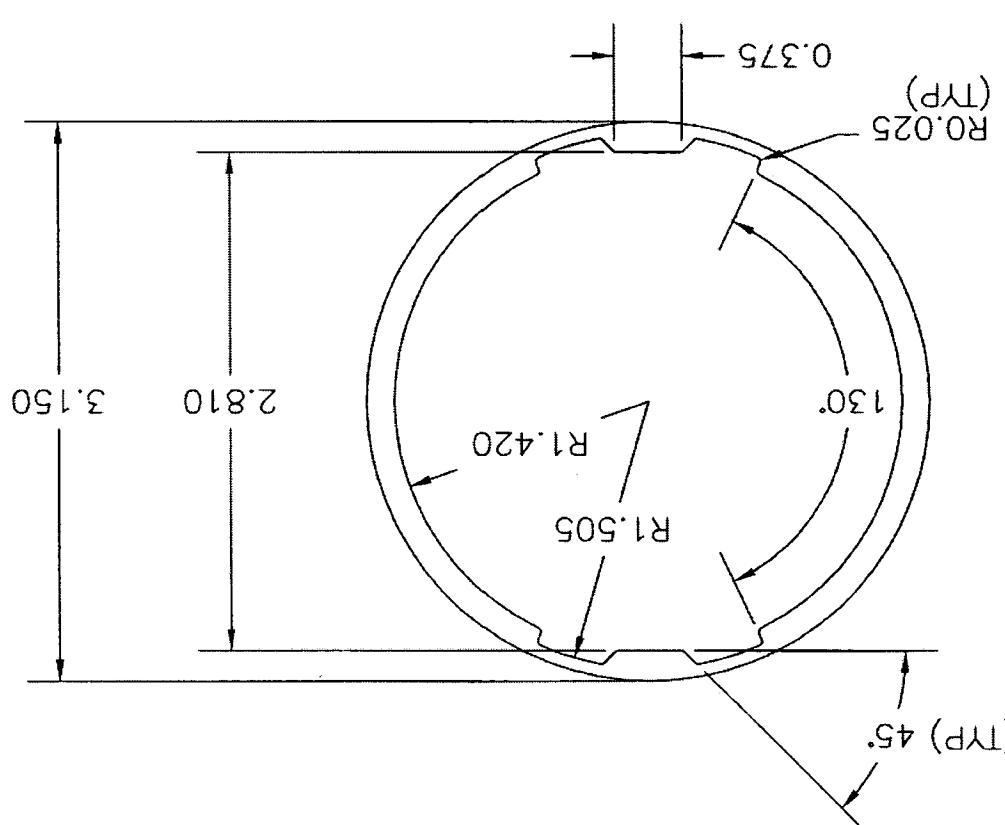
SHEET 3 OF 5

1:1



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98.8.25 DS



MANUFACTURED WITH CARBON INDALUX DIE # MH-18859
OR BON L DIE # 897122 (PREFERRED CHOICE)

D2600-3

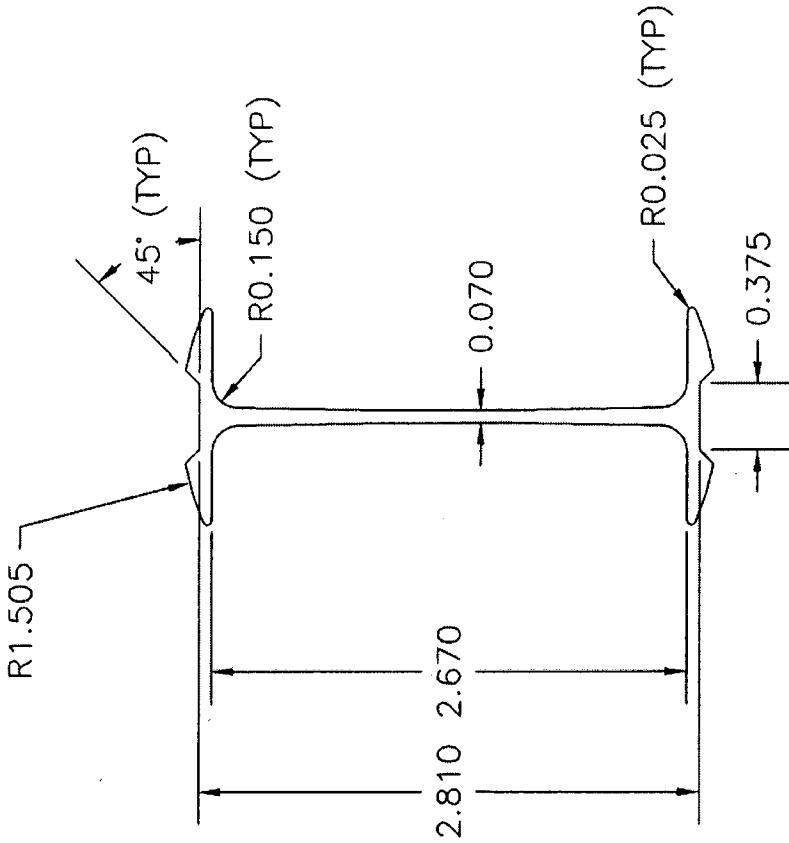
Part number is D2600-3-XXX where XXX is part length in inches (Ex. D2600-3-120 is 120 long)

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DESIGN <i>MR</i>	DRAWN BY <i>DD</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>J</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

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98.8.25. DS

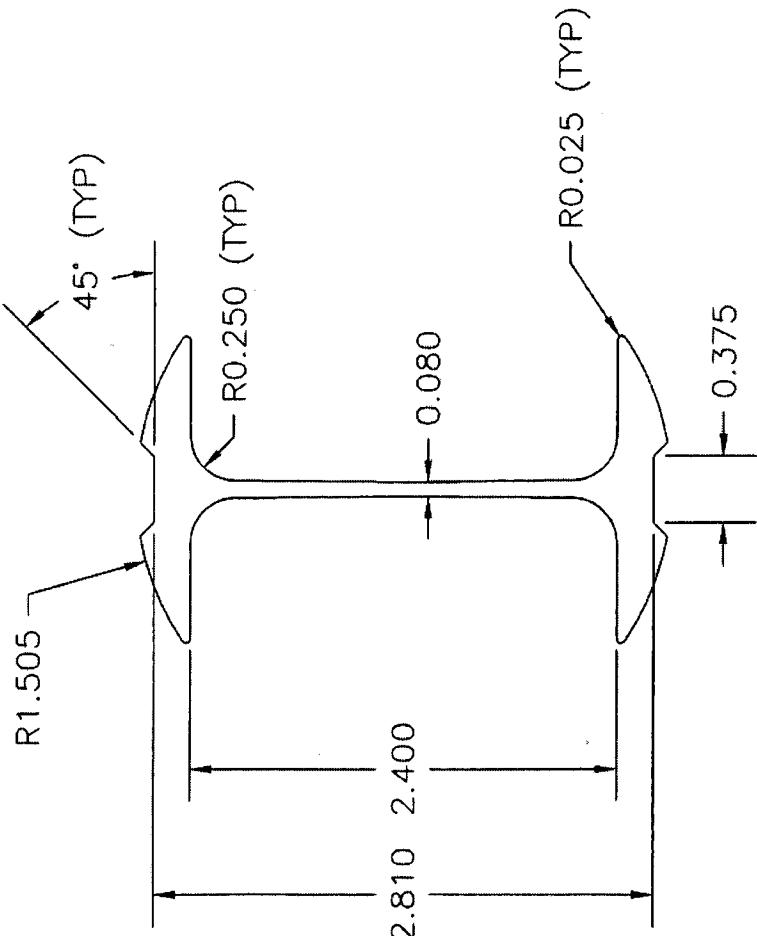
D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(E.G. D2600-5-108 IS 108" LONG)

△
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RE	AS	D2600	SHEET 5 OF 5

DATE
98.08.20TITLE
EXTRUSIONSCALE
1:1**RELEASED**
98.8.25 DSD2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)

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D1